

SPLIT

Date:
User:

Thursday, 2/8/2007 12:43:05 PM
Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: HANDLE WELDMENT
Job Number	: 30719	Part Number	: D3355045
Estimate Number	: 12064	Drawing Number	: D3355 REV B
P.O. Number	: N/A	Project Number	: N/A
This Issue	: 2/8/2007	Drawing Revision	: B
Prsht Rev.	: NC	Material	: N/A
First Issue	: N/A	Due Date	: 2/23/2007
Previous Run	: 29522	Type	: LARGE FAB ASSY
Written By	:	Qty:	2 Um: Each
Checked & Approved By	: <u>[Signature]</u>		
Comment	: est rev A 06.01.20 new issue EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:
---------	-----------------------	--------------

1 0	D33551	handle tip
-----	--------	------------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

pick:

qty	part number	description	batch
1	D3355-1	handle tip	330703

Pl 07-02-10

③

2 0	D33553	LARGE TUBING
-----	--------	--------------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

pick:

qty	part number	description	batch
1	D3355-3	large tubing	326942

Pl 07-02-10

③

3 0	238043	DOWEL PIN .250 X 1.5
-----	--------	----------------------



Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)

pin

Batch: m16684

Pl 07-02-10

③

4 0	VA7130	spring plunger
-----	--------	----------------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

pick:

qty	part number	description	batch
1	VA-7130	spring plunger	m101251

Pl 07-02-10

③

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 2/8/2007 12:43:05 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HANDLE WELDMENT

Job Number: 30719

Part Number: D3355045

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Cpl 07.02.10 (3)



Comment: Weld assembly as per dwg

6.0

QC5/9

WELD INSPECTION

Mo 07/02/12 (3)

7.0

POWDER COATING

POWDER COATING



m18052



Comment: POWDER COATING

Powder Coat Fire Red (Ref: 4.3.5.10) as per QSI 005 4.3

FL/YH 07/02/12 (3)
Mo 07/02/12 (3)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION

9.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Install spring plunger per dwg D3355

Cpl 07.02.12 (3)

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Mo 07/02/13 (2)

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: W521

Cpl 07.02.14 (2)

12.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Mo 07/02/14 (2)

Job Completion



C 07/02/14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

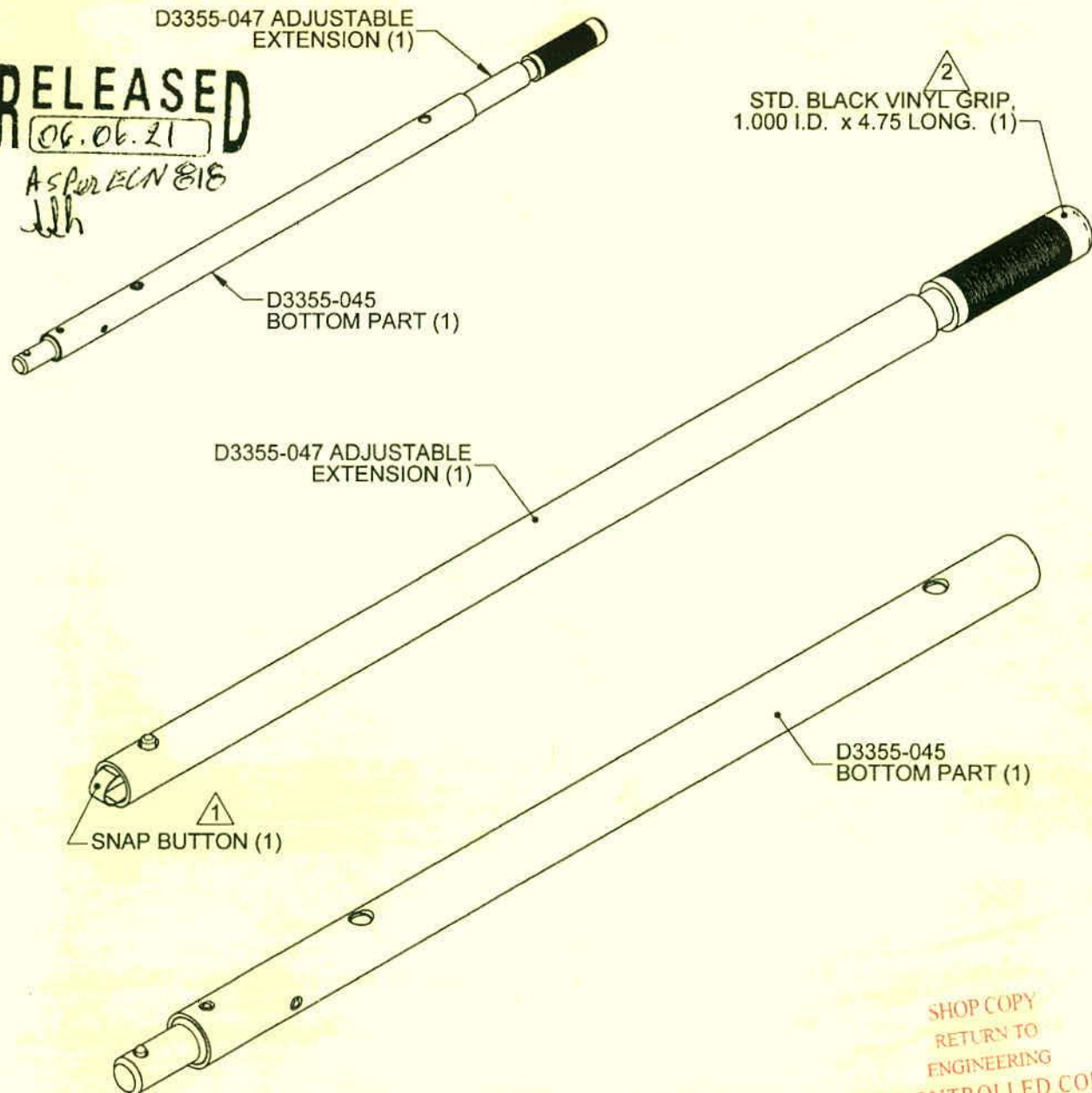
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: 20 Date: 07/02/14
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/02/12	9.0	Hole in A3355-1 was too small to press in VA-7130 spring plunger. Do to that (2) VA-7130 was scrap	<i>[Signature]</i>	- re drill holes for spring plunger - did not replace more in stock	Cpl 07-0213	<i>[Signature]</i> 07/02/13	<i>[Signature]</i> 051042	<i>[Signature]</i> 07/02/12
				- replace one (was only one in stock)				

NOTE: Date & initial all entries

DART

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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3355	REV. B SHEET 1 OF 6
DATE 06.05.31		TITLE HANDLE WELDMENT	SCALE 1:8
A	05.02.07	NEW ISSUE	
B	06.05.31	EDITED NOTE 1 (SHEET 2), UPDATE DETAIL B	

RELEASED
06.06.21*AS PER ECN 818*
llh**D3355-041 HANDLE ASSEMBLY****NOTES:**

- 1) POSSIBLE SUPPLIER: REID TOOLS SUPPLY CO. P/N VA-2160
- 2) POSSIBLE SUPPLIER: REID TOOLS SUPPLY CO. P/N GP-1R

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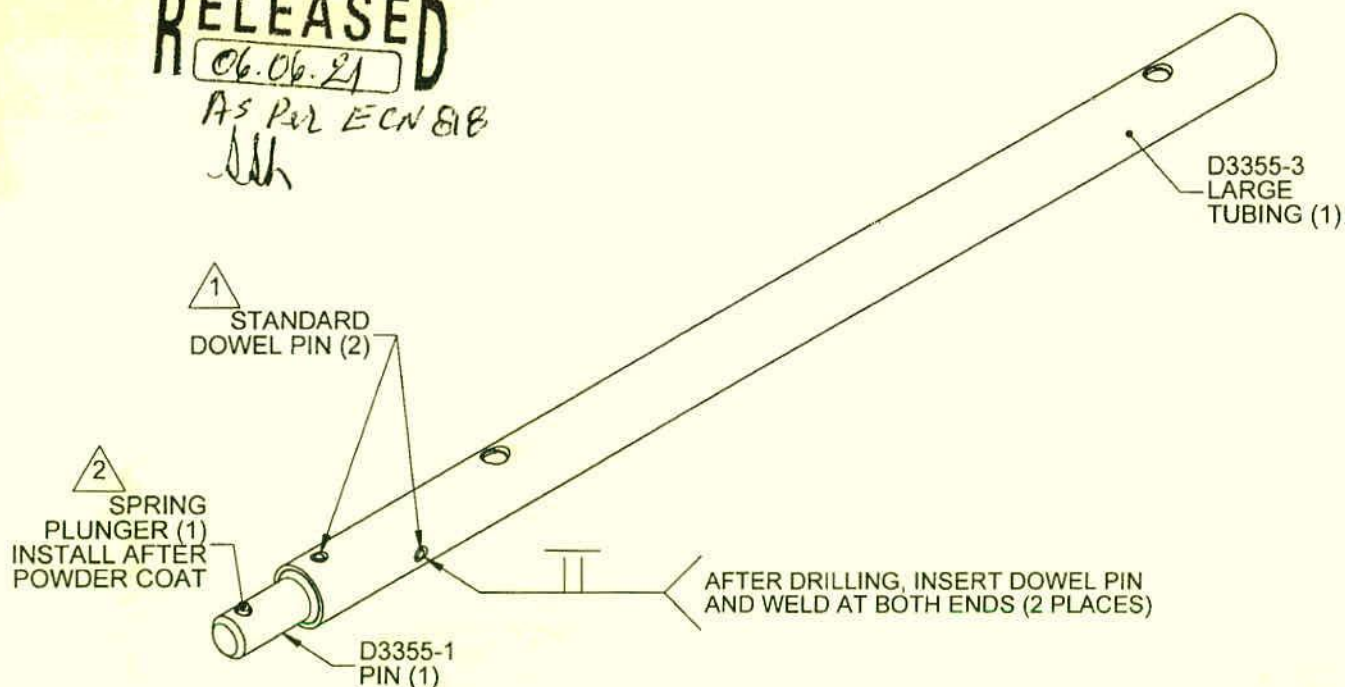


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DATE 06.05.31	TITLE HANDLE WELDMENT	SCALE 1:5	

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06.06.21

AS PER ECN 818

[Signature]



DRILL 90° FROM EACH HOLES
Ø 0.250 (DRILL THRU (2 PLACES) AND
CHAMFER 0.06 x 45° (4 PLACES)

D3355-045 BOTTOM PART

NOTES:

- 1) STEEL STANDARD GROUND DOWEL PIN, Ø 0.250 X 1.50 LONG
POSSIBLE SUPPLIER: SPAENAUR, P/N 238-043
- 2) SPRING PLUNGER, POSSIBLE SUPPLIER: REID TOOLS SUPPLY CO. P/N VA-7130
- 3) WELD PER DART QSI 004
- 4) FINISH: POWDER COAT PAINT FIRE RED (4.3.5.10) PER DART QSI 005 4.5
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) BREAK ALL SHARP EDGES 0.010 TO 0.020

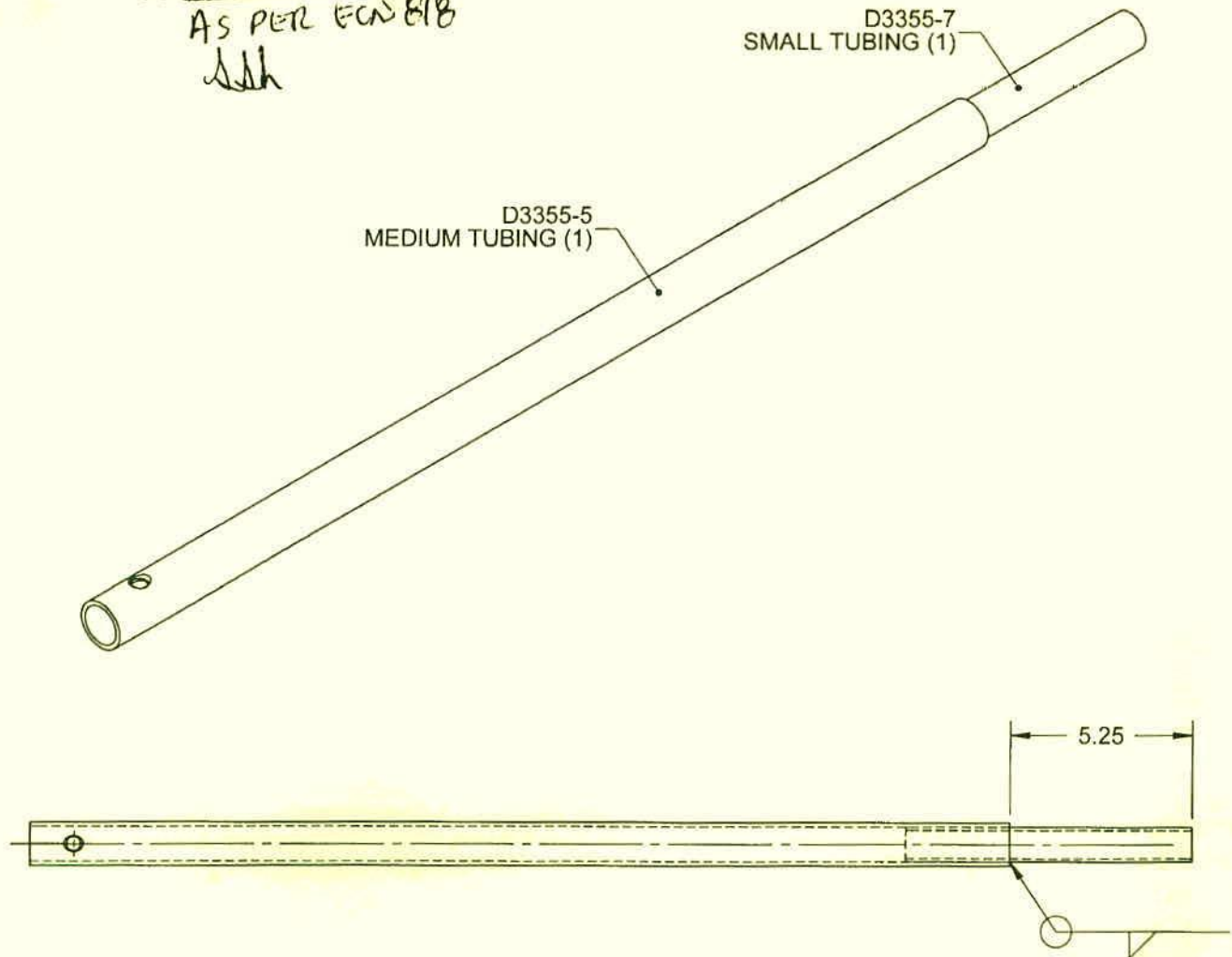
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DATE 06.05.31	TITLE HANDLE WELDMENT	SCALE 1:5	

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06.06.21AS PER ECN 818
ssh**D3355-047 ADJUSTABLE EXTENSION****NOTES:**

- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT PAINT FIRE RED (4.3.5.10) PER DART QSI 005 4.5
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.010 TO 0.020

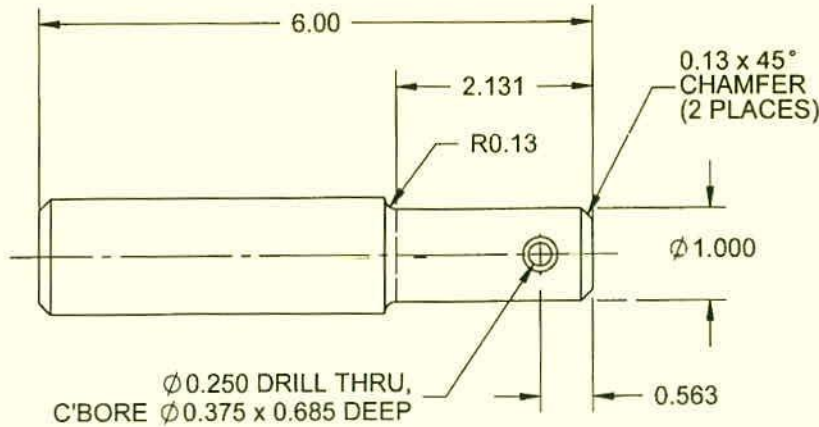
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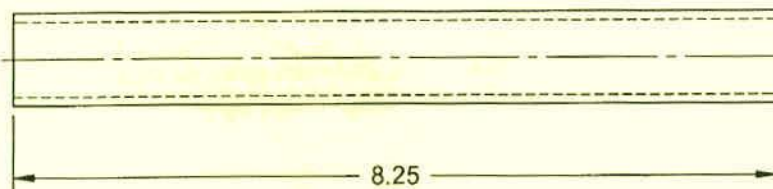
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DATE 06.05.31	TITLE HANDLE WELDMENT		SCALE 1:2

**RELEASED**
06.06.21
AS PER ECN 018**D3355-1 PIN****D3355-1 NOTES:**

- 1) MATERIAL: AISI-4130/ AISI-4140 OR ASTM A304-02/ A-434-BC/ A193-03 - GRADE-B7/ A29-03/ A322-91 OR UNS#-G41400 ROUND BAR, (REF. DART SPEC. M4140H-R)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020

**D3355-7 SMALL TUBING****D3355-7 NOTES:**

- 1) MATERIAL: AISI 1018-1025 MILD STEEL SEAMLESS ROUND TUBING (REF. DART SPEC. M1020TR1.000W.095)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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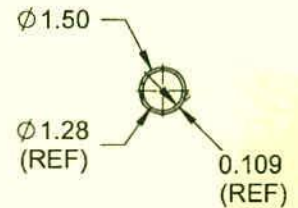
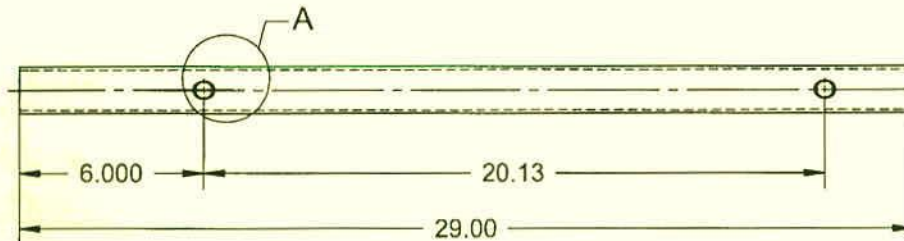
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DATE 06.05.31	TITLE HANDLE WELDMENT		SCALE 1:6

CHAMFER $\phi 0.687$ (11/16)
x 45°, 0.060 DEEP
(2 PLACES)

$\phi 0.531$ (17/32) DRILL
THRU (2 PLACES)

DETAIL A
SCALE 1 : 2



D3355-3 LARGE TUBING

NOTES:

- 1) MATERIAL: AISI 1018-1025 MILD STEEL SEAMLESS ROUND TUBING
(REF. DART SPEC. M1020TR1.500W.109)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.015 TO 0.030

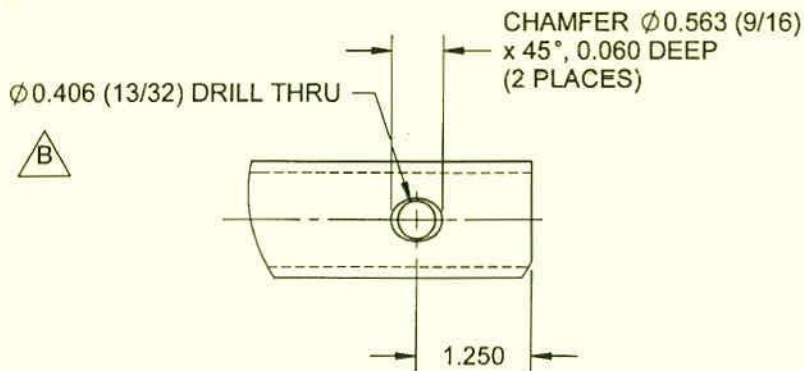
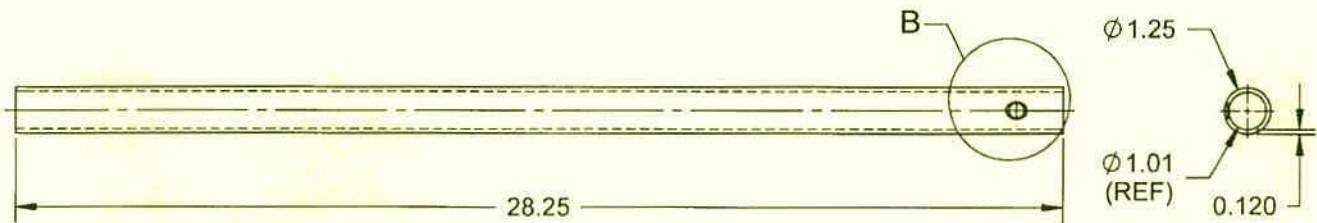
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[Signature]DETAIL B
SCALE 1 : 2**D3355-5 MEDIUM TUBING****NOTES:**

- 1) MATERIAL: AISI 1018-1025 MILD STEEL SEAMLESS ROUND TUBING
(REF. DART SPEC. M1018TR1.250W.120)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.015 TO 0.030

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